

S127328



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D5549-1-Rework
Job Sheet R186262



Part No: D5549-1-Rework Job Qty: 1 ea

Part Name: Fwd Beam



Part Weight: 0 lbs Status: Scheduled Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 11/16/18

Created By: Michelle Gagnon-Donovan

Type: Rework

Description: Rework - ream holes

Note: DWG REV.B SHEETS 5, 6

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Rework Start up	1 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Small Fab-2		18.11.13
110	Rework	1 pcs	11/16/18	11/16/18	0.00	0.00	Small Fab - 6 - B4B		28.11.13
120	Rework	1 pcs	11/16/18	11/16/18	0.00	0.00	QC 5 - 48		28.11.13
190	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-2		28.11.13
200	QC21-SA	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		28.11.13

Part Op 190 - Identify as per dwg & Stock in QC Quarantined for RA72

Descriptions: 190 - Identify as per dwg & Stock in QC Quarantined for RA72

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5549-1	Fwd Beam	1 Ea (1 ea)	100-Rework Start up	S124388

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Rework Start up	D5549-1	1	1	0

Part Specifications

Specifications could not be found.

Plex 11/13/18 11:26 AM Dart.Gagnon.Michelle

P.T.O.

NCR No.

19-7156

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: <u>R186262</u> Part No. <u>DSS49-1</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>18-11-13</u>		Sequence #: _____		QTY Affected: <u>1</u>	
Description Work Order Deviation <u>(Qty) (1) φ0.377 to 0.002 hole is mis-aligned and does not allow assembly with pip pin.</u>		Disposition <u>Acceptable to open gty(1) hole to φ0.386 to 0.002 to allow pip pin installation. Verify fit by test assembly per dwg DSS49 Rev.B</u> <u>-PARTS ASSEMBLED AS PER DWG DSS49 REV B, PIP PIN HAS PROPER CLEARANCE.</u>		Completed By: <u>DAS 68</u> <u>JAN 07 2019 9-89</u> Lead hand / Supervisor <u>DAS 9</u> <u>JAN 07 2019 9-89</u> QC / QA Coordinator <u>DAS 9</u> <u>JAN 07 2019 9-89</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☐ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐			
Other/Details: _____		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J

Chris Provencal

From: Chris Provencal
Sent: Monday, November 12, 2018 4:50 PM
To: 'David Shepherd'
Subject: NCR D5549-011 (D117-1044 Basket)
Attachments: NCR-D5549-041.jpg; IIN.jpg

David,

RE: D5549-011 Fwd Beam Assembly

The qty(1) pip pin hole in the D5549-1 Fwd Beam was misaligned with the D5553-1 Bracket that together captures the D5069 a/c attachment adapter (ref attached IIN.jpg). The misalignment was side-to-side and was enough to just prevent the pip pin from passing.

The $\varnothing 0.377+0.002/-0.000$ hole was opened with a $\varnothing 0.386$ reamer in the D5549-1 Fwd Beam (only) allowing the pip pin to pass thru. $\varnothing 0.386$ is the standard for a “close” fit for a 3/8” bolt.

The hole in the D5553-1 Bracket is unchanged, which is what captures the pip pin. Even if the pip pin were to be installed backwards, the $\varnothing 0.386$ hole doesn’t allow the 0.440 wide pins to pass through without pushing the pip pin button. When assembled with the D5069-1 Adapter (attached photo), there is enough play in the entire system that the pip pin bears on all surfaces under load.

Would you agree that this is acceptable?

Sincerely,

Chris Provencal, P.Eng
Senior Engineer

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